

Page 1

Tuesday, April 19, 2011 3:47:55 PM Item ID: **Revision ID:** Item Name: Required Date: 5/13/2011 Reference: Sequence ID/ **Draw Nbr** D3391 100 Skidtubes Skidtubes 110

D3391-021

Accept



Setup Start

Stop



Fwd Tube Assembly

**Start Date:** 

4/19/2011

Start Qty: 1.00 **Req'd Qty:** 1.00



**Cust Item ID: Customer:** 

Approvals:

Process Plan: \_\_\_\_\_\_\_\_

Date: 11-04-19

Tooling:

Date: Date:

Run

Start

QC:

Date:

SPC (Y/N):

Tool # Plan

Accept

Reject Qty

Reject

Insp.

**Work Center ID** 

Operation Description

**Revision Nbr** 

Set Up/

**Run Hours** 

Tool ID

Code

Qty

Stop

Number

Stamp

Rev H

Skidtubes

Memo

0.00

0.00

Cut extrusion to 46.52 +0.010 -0.020

CNC Bend 1

**BENDING MACHINE - SKIDTUBES** 

Memo

0.00

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

37. 1

120

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

Dart Aerospace L
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W/O:				WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE	RE CHANGE			Date Q1	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:PAR #:F											
	R	esolution:	Dispo	sition:	QA	: N/C Clo	sed:	Date: _			
NCR:		V	VORK C	PRDER NON-CO	ONFORMANCE	E (NCR)					
DATE	STEP	Description of NC		Corrective Ac		Verification	n Approval	Approval			
DAIL	SIEP	Section A	Initial Chief En		Description lef Eng	Sign & Date	Section C		QC Inspector		
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## Work Order ID 68667

Tuesday, April 19, 2011 3:47:55 PM



Page 2

Item ID:

D3391-021

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Fwd Tube Assembly

**Start Date:** 

4/19/2011

QC:

Start Qty: 1.00

Required Date: 5/13/2011

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/ **Work Center ID** 

130

HAAS 1

HAAS CNC vertical machine #1

Operation Description

Set Up/

Date:

0.00

0.00

**Run Hours** 

& Dwg D3391 Rev.

RP 11.5.6

Tool ID

Tool # Plan Code

Accept Reject Qty **Qty** 

Run

Reject Number Stamp

Insp.

HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. Identify as D3391-1

2-Deburr

Memo

Memo

140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

'u. 5.6

0.00

150

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

0.00

Drill X1 Aft cap as per Dwg D3391 .1875" dia

Dantac	loopade En	•						
W/O:			WORK ORDER				•	
DATE	STEP	PROCEDU	RE CHANGE	By Date	Qty	Approval Chief Eng / Prod Mgr	Approvál QC Inspector	
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		÷						
Part No	) <b>:</b>	PAR #: Fa	ult Category:	NCR: Yes No I	DQA:	Date: _		
	Reso	lution: Di	sposition:	QA: N/C Closed:		Date: _	<u> </u>	

WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC			Corrective Action Section B		Verification	Approval	Approval QC Inspector
STEP	Section A			Action Description Chief Eng	Sign & Date	Section C	Chief Eng	
	STEP	STEP Description of NC	STEP Description of NC Section A Ini	STEP Description of NC	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B  Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section A Action Description Sign & Section C	STEP Description of NC Section A Description A Description A Description A Description Section B Section C Chief Eng

NOTE: Date & initial all entries

# Work Order ID 68667

Tuesday, April 19, 2011 3:47:55 PM



Page 3

Item ID:

D3391-021

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name: Fwd Tube Assembly

Required Date: 5/13/2011

4/19/2011

Start Qty: 1.00

QC:

Req'd Qty: 1.00



Date: \_\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Accept

Qty

Run Start

Reject

Qty

Stop

Reject

Number

Stop



Insp.

Stamp

Sequence ID/

**Work Center ID** 

160

Quality Control

Operation **Description** 

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 

0.00

0.00

11.05.07 1

170

QC

QC8- Inspect parts - second check

Memo

0.00

0.00

Memo

Quality Control

Dart	<b>Aeros</b>	pace	Ltd
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W/O:				V	VORK ORDER CHANGES	<u> </u>				
DATE	STEP	PROC	EDUR	RE CHANGE By			Date	Qty	Approval* Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:			_ Dis	posit	tion:	QA: N/C (	closed:		Date: _	
NCR:		W	ORK	OR	DER NON-CONFORMAN	CE (NC	R)			
DATE	STEP	Description of NC Section A	<b>Init</b> Chief		Corrective Action Section Action Description Chief Eng	Sign Date	&   Sec	i <b>cation</b> tion C	Approval Chief Eng	Approval QC Inspector
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## Work Order ID 68667

Item ID:

**Revision ID:** 

**Item Name:** 

**Start Date:** 

Reference:

Approvals:

**Required Date: 5/13/2011** 

Tuesday, April 19, 2011 3:47:55 PM

. D3391-021

4/19/2011

Fwd Tube Assembly



Page 4

Date: \_\_\_\_\_ SPC (Y/N): Sequence ID/ Operation Set Up/ Work Center ID Description Run Hour 180 0.00 Skidtubes Skidtubes 0.00 Memo Skidtubes holes to finish size) (ONLY DRILL HOLES MARKED "A") holes drilled in previous step 3-Open tow cap holes to .208" as per Dwg D3391 4-Open Tow Ring hole to .640" as per Dwg D3391 6-Deburr & Scribe Batch number Inside aft end. 7-Transfer drill D3391-021 with D3391-023 190 QC5- Inspect part completeness to step on W/O Memo Quality Control

Start Qty: 1.00

Req'd Qty: 1.00

Date:

Process Plan:

Setup	Start		
	Stop		
Run	Start		
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		Stop Run Start	Stop Run Start

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap

Accept

Tooling:

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875"

5- open float bag holes 0.328" and counter sink as per dwg D3391

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W/O:			WORK ORDER CHANGES						•	
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### Work Order ID 68667

Tuesday, April 19, 2011 3:47:55 PM



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Item ID:

D3391-021

Accept

Setup Start



**Revision ID:** 

Item Name:

Required Date: 5/13/2011

Fwd Tube Assembly

**Start Date:** 

4/19/2011

Start Qty: 1.00

**Req'd Qty:** 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date: Date:

Run



Stop

Start

Stop

Sequence ID/ **Work Center ID** 

200

HandFinish

Operation **Description** 

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Hand Finishing

Memo

0.00

210

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

0.00

220

Skidtubes

Skidtubes

Skidtubes

Memo

1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: MILGO?7

exp. date: 11-8-30 cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

0.00

Part No:PAR #:Fault Category:NCR: Yes No DQA:Date:NCR:NORE:NORE:NORE:NORE:NORE:NORE:NORE:NORE:NORE:NORE:		•;		-			S	RDER CHANG	ORK ORI	V					W/O:
Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B			Chief Eng /	Qty Chief Eng /	Date	Ву		RE CHANGE			ROCEDUF	PR		STEP	DATE
Resolution: Disposition: QA: N/C Closed: Date:  NCR: WORK ORDER NON-CONFORMANCE (NCR)  Corrective Action Section B															
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NOTE: Date & initial all entries

### Work Order ID 68667

Tuesday, April 19, 2011 3:47:55 PM



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Item ID:

D3391-021

Accept

Setup Start



**Revision ID:** 

Item Name:

Fwd Tube Assembly

**Start Date:** 

4/19/2011

Start Qty: 1.00

Required Date: 5/13/2011 Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Process Plan:

Date: Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/ **Work Center ID** 

230

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

0.00

0.00 8 11/05/15

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject\_ Number Stamp

Insp.

235

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

240

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

START TIME: 2:05 FINISH TIME

0.00

0.00

\_/\_BR 11-5-19.

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W/O:			W	WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQA</b> :	Date: _					
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR	)						
DATE	STEP	Description of NC	Initial .	Corrective Action Sect Action Description	ion B	Verification		Approval				
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Work	Order ID	68667
Tuesday	April 10 2011	3.47.55



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Tuesday, April 19, 2011 3:47:55 PM												
Item ID: Revision ID:	D3391-021			Accept				s	etup Sta	rt		
Item Name:	Fwd Tube Ass	sembly							St	op    q		
Start Date: 4/19/2011 Required Date: 5/13/2011 Reference:		Start Qty: 1.00 Req'd Qty: 1.00		<i>;</i>	Cust Item ID: Customer:					i (mainthi	11010 116 1101 1201	
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		Run		irt		
			Date:	SPC (Y/N):		ate:			St	op		
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
250		QC3- Inspect Part Finish		0.00				1	d	H	1105/20	
QC Quality Control		Memo		0.00			_		-Ψ		1(1081	
255				0.00								
		Skidtubes						1	6	PK	ilos(20	
Skidtubes Skidtubes		Memo **** install D DWG ****	3591-1 spacer as per DSI	0.00 9364 and wearplate and	gasket as per							
257		QC5- Inspect part complet	reness to step on W/O	0.00	1							
QC Ouality Control		Memo		0.00	02/57		_	A				

W/O:				WC	RK ORDER CHANG	GES					ı
DATE	STEP	PRO	CEDUR	RE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Faι	it Cate	gory:	NCI	R: Yes	No <b>DQ</b>	A:	_ Date: _	
Resolution: Dis			positio	n:	QA	N/C CI	osed:		Date: _		
NCR:		V	VORK	ORD	ER NON-CONFORM	IANCE	(NCF	R)			
DATE	STEP	Description of NC	Corrective Action						cation	Approval	Approval
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NOTE: Date & initial all entries

### Work Order ID 68667

\*Tuesday, April 19, 2011 3:47:55 PM



Page 8

Item ID:

D3391-021

Accept

Accept

Qty

Setup Start

Stop

Stop



**Revision ID:** 

Item Name:

Fwd Tube Assembly

**Start Date:** 

4/19/2011

Start Qty: 1.00

Required Date: 5/13/2011

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:\_\_\_\_\_

Date:

Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Start Run



Insp.

Stamp

Sequence ID/

**Work Center ID** 

260

Packaging

Packaging

**Operation Description** 

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

D4R-742-043/368645

Code

Tool # Plan

Reject

Qty

Reject

Number

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

Memo

0.00

MF (1-05-24

W/O:	WORK ORDER CHANGES							<b>3</b> °			
DATE	STEP	PROCE	DURE	E CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOTE: Date & initial all entries

### **Picklist Print**

Tuesday, April 19, 2011 3:47:48 PM

Work Order ID: 68667

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 4/19/2011

Start Qty: 1.00

Required Date: 5/13/2011

Page 1

Required Qty: 1.00

Comments:

IPP A□05.09.13□New issue□

KJ/JLM□

IPP B□06.02.10□Dwg rev.D ecn 773 □EC□ IPP C□06.05.02□Added inspections

 $\Box$ EC $\Box$ 

IPP D 07.03.13 rev F dwg

EC EC verified by: DD

IPP E 07.11.07 revG dwg ecn1053P IPP Rev:f ECN 1056 07-11-12 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev J 09.02.02 added hardware EC verifified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047		Manufactured	No			100	Each	31.0000	1	1			
Skiutuoc Material				Location	1	Loc	Qty	Loc Code		2			

D3670-4-200

Manufactured No

Manufactured

No

LG 26547

31 31 220 100.0000 Each



**SPACER** 

D3401-041

Location	<u>L</u> .	oc Qty	Loc Code
LG		100	
67777		39	
68107		61	
	255	Each	18.0000

Tow Cap Assembly

Location Loc Oty FP007 18 46029 6 61505 12

Loc Code

Dart	<b>Aeros</b>	pace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORD	ER NON-CONFO	RMANC	E (NCF	R)			
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Tuesday, April 19, 2011 3:47:49 PM

Work Order ID: 68667 D3391-021 Parent Item: Parent Item Name: Fwd Tube Assembly Required Date: 5/13/2011 **Start Date: 4/19/2011** Start Qty: 1.00 Required Qty: 1.00 D3564-13 Manufactured No 255 Each 38.0000 Wearshoe Location Loc Qty Loc Code FP017 38 66136 16 66549 6 66805 16 D3566-13 Manufactured 255 No 41.0000 Each Gasket Location Loc Qty Loc Code FP014 41 \_66550 21 68341 20 NAS1149C0332 R AN960C10L Purchased No 255 Each 0.0000 10 10 M117241 washer AN3C4A Purchased No 255 Each 2,358.000 10 10 BOLT Location Loc Oty Loc Code ST350 2358 116924 358 XID 117094 1000 117313 1000

W/O:		WORK ORDER CHANGES								
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DATE	STEP	Description of NC		Section B		ation	Approval	Approval		
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NOTE: Date & initial all entries

### **Picklist Print**

Tuesday, April 19, 2011 3:47:49 PM

Page 3

Work Order ID: 68667

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 4/19/2011

Required Date: 5/13/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Phenolic Washer

255 Each

1,387.000

	Location	Loc Qty	Loc Code	
	FP-A	37		
	52505	37		v 4
	ST074	1350		
	64177	850		
	66821	500		
No		255 Each	0.0000	(xz) JU (105120
No		255 Each	0.0000 6 8	10 10 kg 105(20

AELS-1032-130 Purchased **INSERT** 

AELS-1032-225

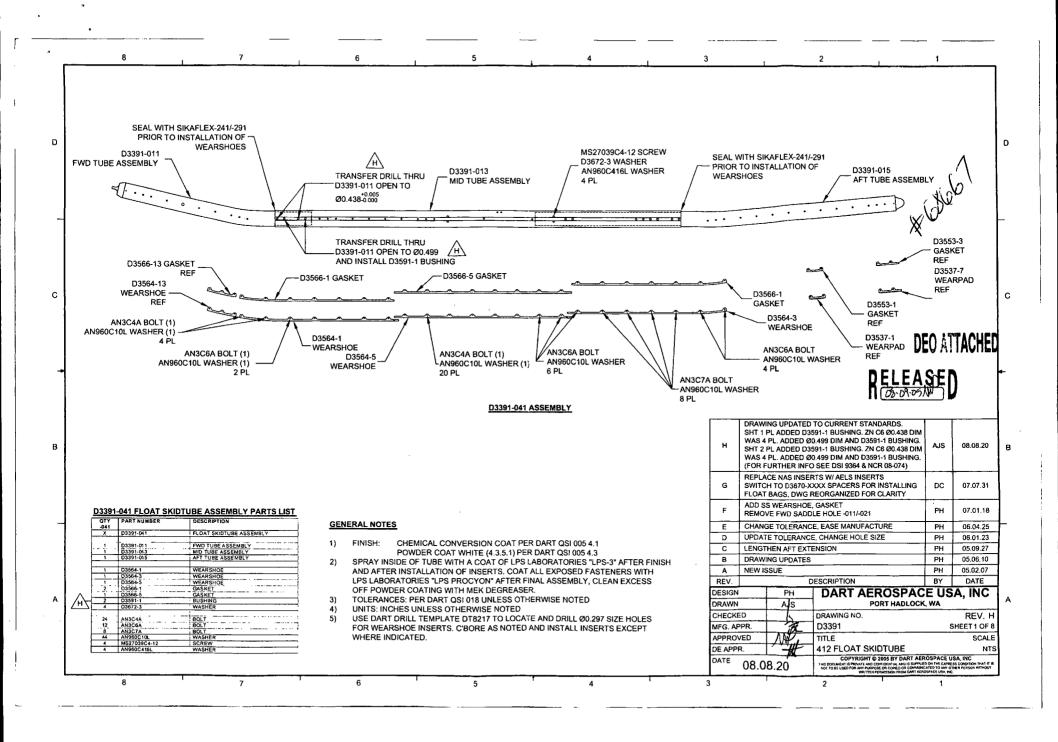
Purchased

No

No

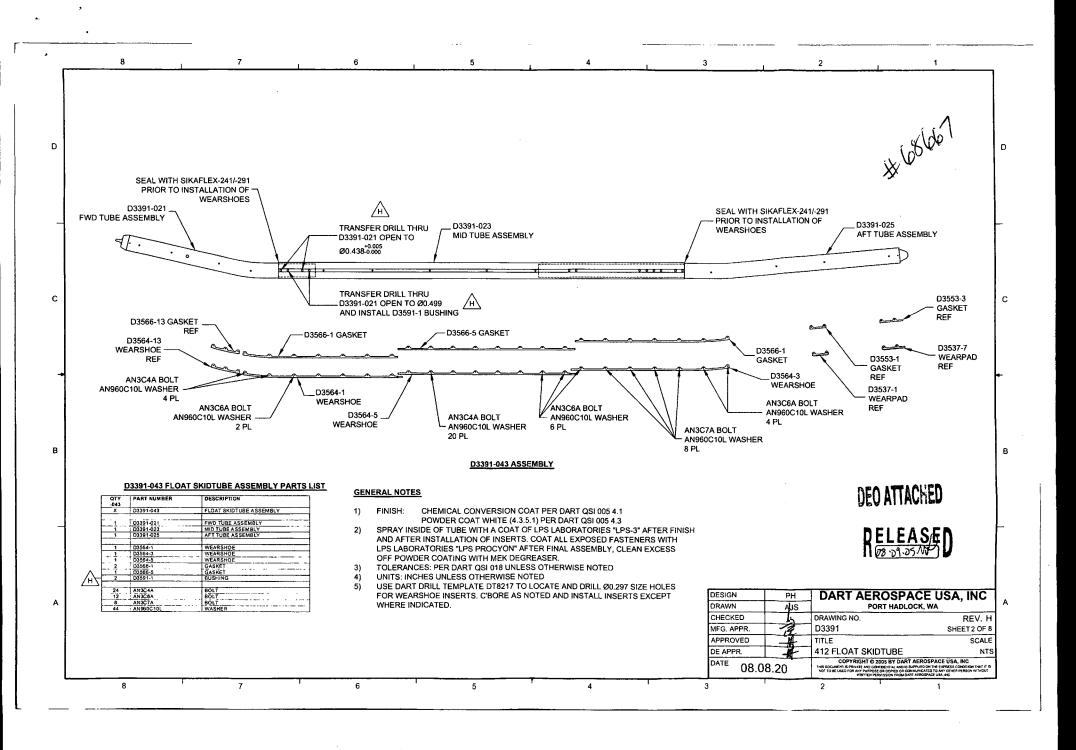
INSERT

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NCR:			WORK ORD	ER NON-CONFO	RMANCI	E (NCF	1)			
DATE	STEP	Description of NC		Corrective Action	Section B	Ciara e		cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descri Chief Eng	tion	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
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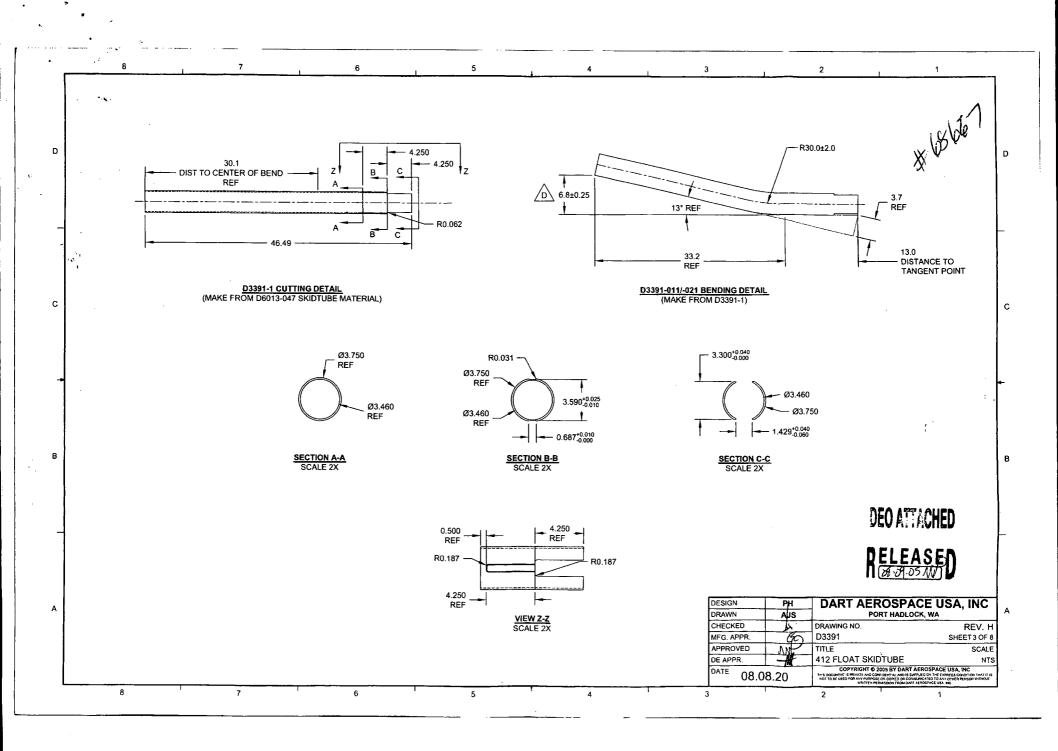
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NOTE: Date & initial all entries



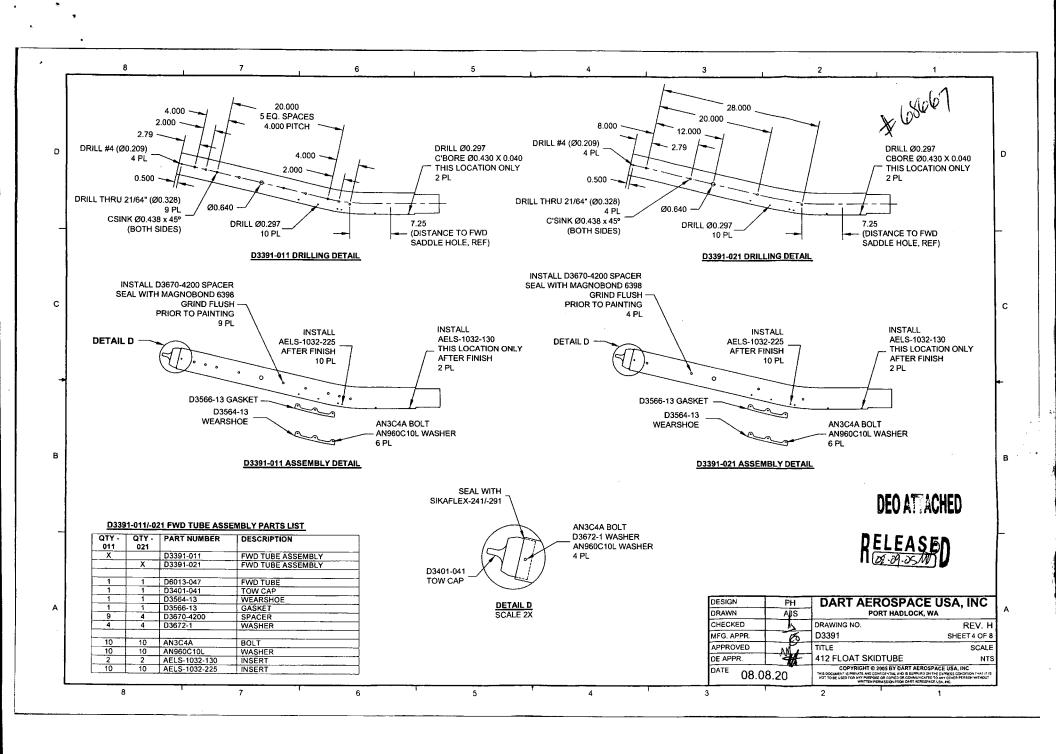
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NOTE: Date & initial all entries



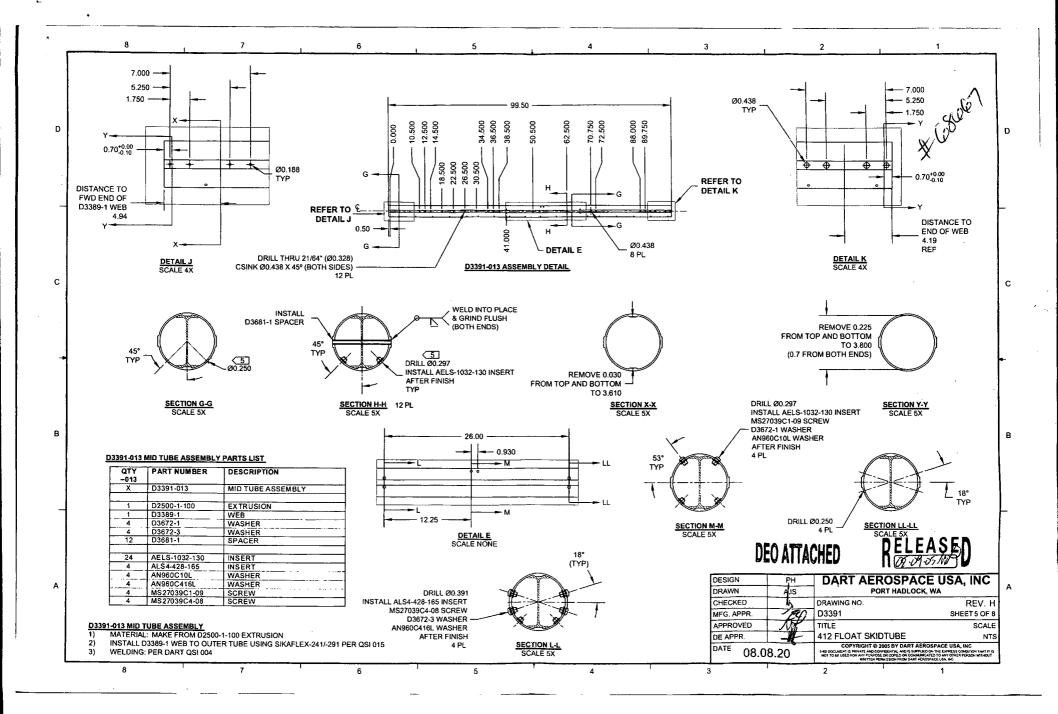
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NOTE: Date & initial all entries



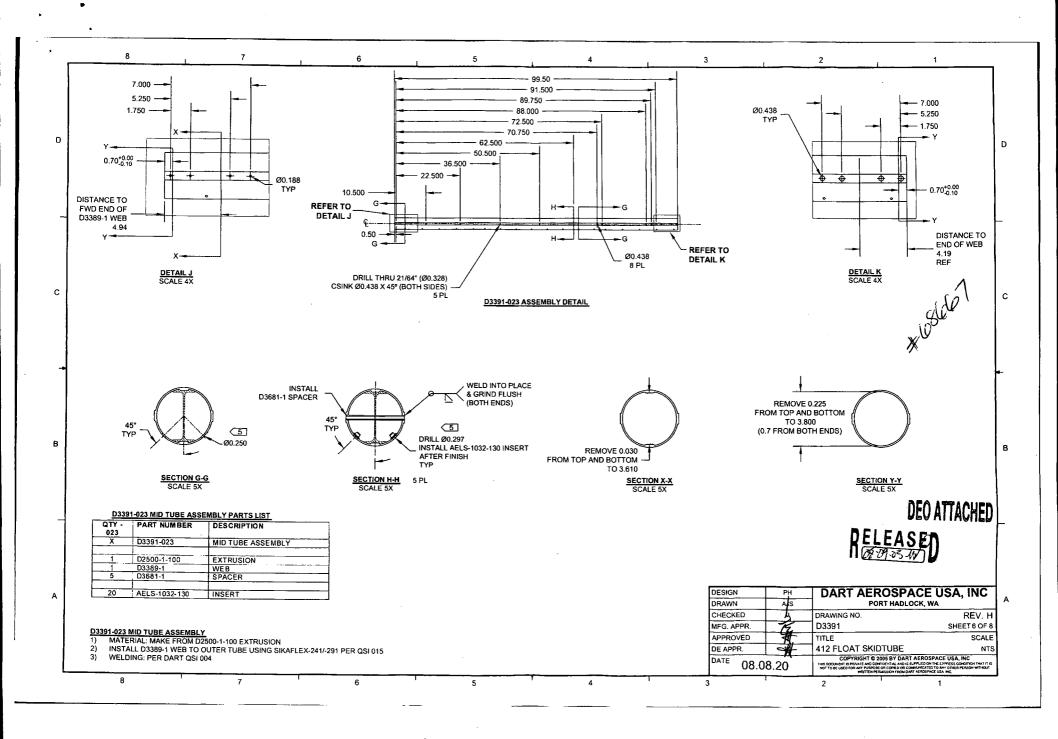
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NOTE: Date & initial all entries



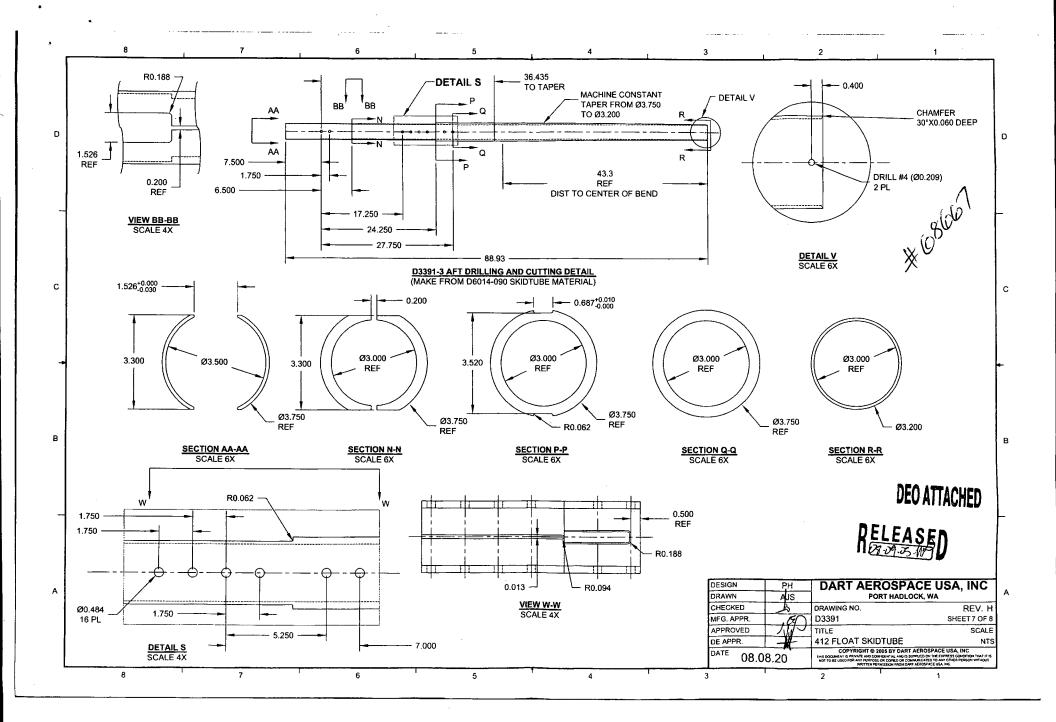
<b>Dart Aerospace</b>
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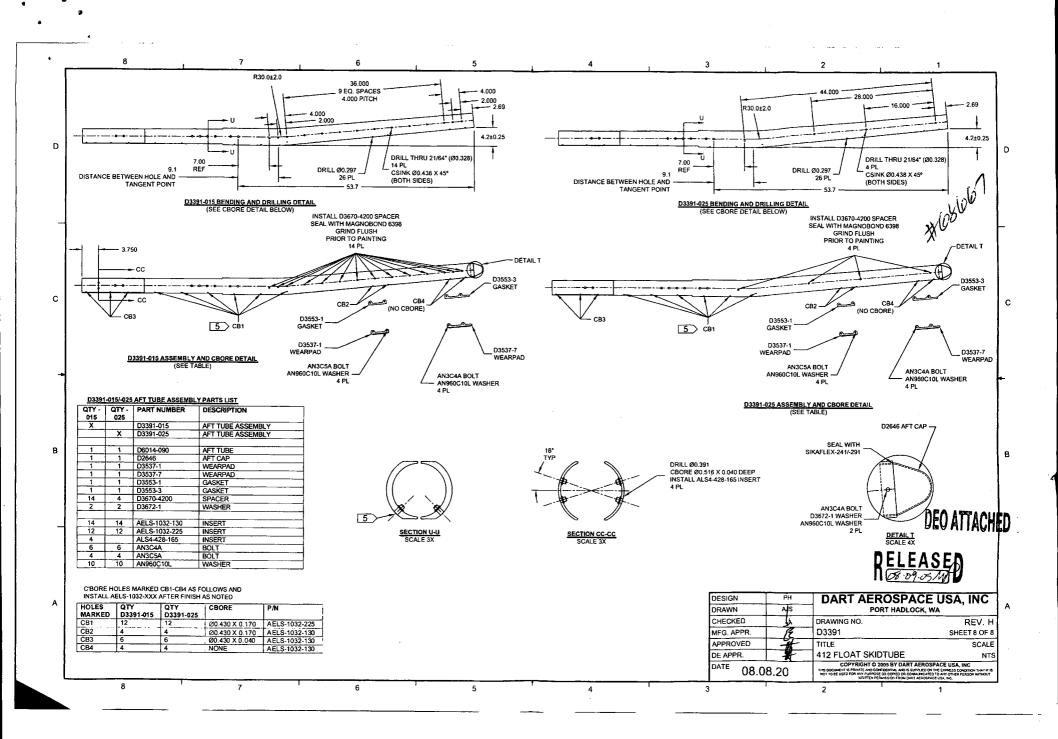
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NOTE: Date & initial all entries



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# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Inspector Approval Chief Eng / Prod Mgr QC Inspector

Part No:		PAR #:	Fault	Category:	NCR: Yes No	DQA:	Date:	
	Resolution:		Dispo	sition:	QA: N/C Closed		Date:	

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		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
DATE	STEP	Section A	Initial Chief Eng			Section C	Chief Eng	Approval QC Inspector					

NOTE: Date & initial all entries

DRAWING	NO.	TITLE		REV. H DA	ART AE	ROS	PACE USA, II	C D.E.C	D. NO.		SHE	ET NO.		SCALE
D3391		412 FLOAT	SKIDTUBE	,	ENGI	NEER	ING ORDER	D33	91-H-1	_	SHEE	T 1 OF,	1	NTS
DRAWN	- G	)	CHECKED	l,	MFG. AP	PR.	Δ	APPROVI	ED MA	)	DE APPR.	-#	 > .	
DATE	09.09.	23	DATE O.	04.24	DATE	09/	09/25	DATE	09/09/	30	DATE	09/0	9/3	>

### **PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

### **CHANGE:**

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT-OF-LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

DELEASED 2010 -02- 0 2

AMP (C) lobo

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W/O:				WORK ORDER CH	IANGES			· · · · · · · · · · · · · · · · · · ·
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DART AEROSPACE LTD	Work Order:	
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: H		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	,690			120.02	
3.590	+0.025/-0.010	3-607				
3.300	+0.040/-0.000	3.327			)	
1.429	+0.040/-0.060	1.417			. /	
4.250	+/-0.010	4.250				
4.250	+/-0.010	4.250				
19.				•		
,500	+1-010	,499	_		CANUL	
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Measured by: Audited by:	Prototype Approval:	N/A
Date: 11.12-6 Date: 11.05 10	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM
В	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM
С		Dimensions removed per Dwg rev. F	KJ/JLM
D	07.11.23	Dwg Rev. updated	KJ/EC/DD
Е	09.12.14	Dwg Rev updated	KJ 46- M

